

Work Order ID 119232

119232

Page 1

May-14-14 10:21:37 AM

Item ID: D4634-043

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 5/14/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/14/14

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: MLJ

Date: 14-05-14

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4634

F

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

① S.A.O. 04/06/14

110

0.00

110

Small Fab

Memo

0.00

Small Fab

BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC-WELD 2 ON TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR
PLASTIC-WELD 2 BATCH: m/29007

1- Assemble as per Dwg D4634-043

2- Install led lights

3- Install Air valves

4-Install wiring harness

① S.A.O. 14/09/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

DAS
16
9-89

14/06/11

120

QC

Memo

Quality Control

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

PPP117812

0.00

Packaging

1 14-06-12 8

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

Quality Control

0.00

MCS 14-06-12

unf
14-6-12

DQA: _____ Date: _____



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Equip/Tooling											
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FAULT CATEGORY			
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Picklist Print

May-14-14 10:21:43 AM

Page 1

Work Order ID: 119232

119232

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 5/14/14

Required Date: 5/14/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Doc Release DL VERIFIED BY:JLM
13/07/09 DL verf: DD
DL
IPP Rev B
IPP Rev C Dwg Update
IPP Rev. D Dwg Update 13/12/23
IPP REV E Dwg Update 14/01/20 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4634-143		Manufactured	No			100	Each	0.0000	1	1			
D4634-143						B119242			**	SAD 14/06/10			
Middle, Center Ceiling Replacement Panel Assembly													
D4646-1		Manufactured	No			100	Each	60.0000	2	2			
D4646-1									**	SAD 14/06/10			
Plenum Cap Assembly													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				MF3			60						
				113286			12						
				114005			48						
D4652-1		Manufactured	No			100	Each	54.0000	2	2			
D4652-1									**	SAD 14/06/10			
Air Valve, 1.16 Id Disk Type													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				MF3			54						
				111777			3						
				111958			51						
D4728-053		Manufactured	No			100	Each	1.0000	1	1			
D4728-053									**	SAD 14/06/10			
Cabin Lights #2													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				MF7			1						
				113664			1			B116298			

DQA: _____ Date: _____



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FAULT CATEGORY

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Picklist Print

May-14-14 10:21:43 AM

Work Order ID: 119232

119232

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 5/14/14

Required Date: 5/14/14

Start Qty: 1.00

Required Qty: 1.00

PLT1.5M-M

Purchased No

100

Each

643.0000

3

3

**

SAD 14/06/10

PI T1 5M-M

Tie-Wrap

Location

Loc Qty

Loc Code

ST389

643

124363

2

m126551

641

100

Each

71.0000

2

**

SAD 14/06/10

2351-20-27-C3C

2351-20-27-Z3CT

Purchased

No

2351-20-27-C3C

STUD

Location

Loc Qty

Loc Code

MF5

29

m126740

2

m128068

27

ST396

42

m127922

42

100

Each

578.0000

2

**

SAD 14/06/10

50-009-2

Purchased

No

50-009-2

Grommet

Location

Loc Qty

Loc Code

MF5

31

m128022

31

ST378

547

122594

1

m128022

14

m128047

532

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

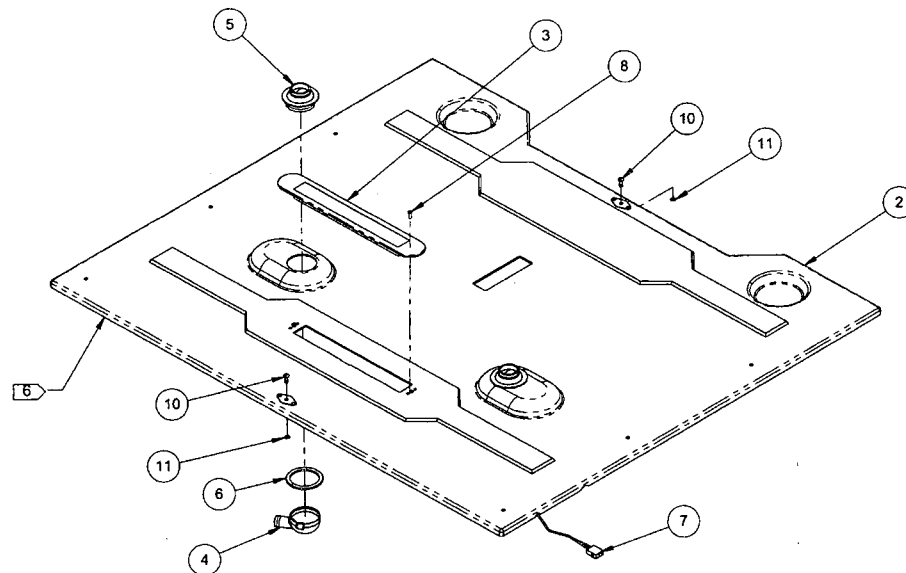
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-051)
4	2	D4646-1	PLENUM CAP ASSEMBLY
5	2	D4652-1	AIR VALVE
6	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-1)
7	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4728-053)
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
10	2	2351-20-27-C3C	STUD
11	2	50-009-2	GROMMET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 119232 MJS

1405-14

D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

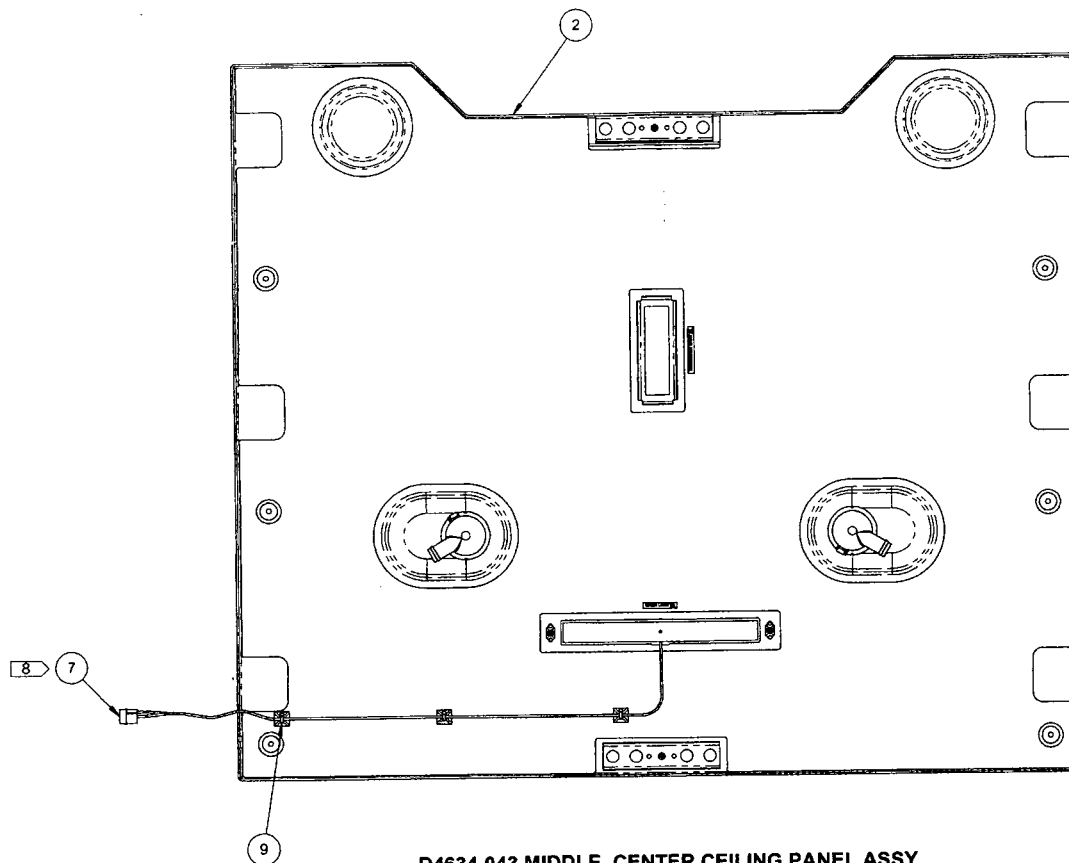
RELEASED

2014 FEB 25 47

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. F
MFG. APPR.	AL	D4634	SHEET 3 OF 17
APPROVED	AL	TITLE	SCALE
DE APPR.	AL	CENTER CEILING PANELS	NTS
DATE	14.02.03	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED
2014 FEB 25 *ap*

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>DC</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>AL</i>	D4634	SHEET 4 OF 17
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AT</i>	CENTER CEILING PANELS	NTS
DATE	14.02.03	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	